

Work Order ID 79154

79154

Page 1

January-23-12 7:39:33 AM

Item ID: D3929-042

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Gusset Assembly

Stop ***NS2***

Start Date: 23/01/2012 Start Qty: 6.00

6

Cust-Item ID:

Required Date: 27/01/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: M.L.J.

Date: 12/01/23 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3929	A

100 0.00

100

Waterjet

Memo

0.00

B12-1-24

FLOW CNC Waterjet

1-Cut as per Dwg D3929

Dwg Rev: A

Prog Rev: A

(8)

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

B12-1-24

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

8/12/12/74

(x8)

Quality Control

140

0.00

140

Large Fab

Memo

0.00

Weld bushings D3907-1 as per dwg D3929

316L rod batch: M118366

PL12.03.14

8x 9

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

150

QC

Memo

0.00

12.03.14

Quality Control

W/O:		WORK ORDER CHANGES					
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Page 3

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6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

8/2/14

(x8)

Quality Control

170

Identify as per dwg & Stock Location:

0.00

170

Packaging

Basket cell

Memo

0.00

Packaging

12.03.14 8x

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/3/15

12-03-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Page 1

January-23-12 7:39:36 AM

Work Order ID: 79154

79154

Parent Item: D3929-042

D3929-042

Parent Item Name: Gusset Assembly

Start Date: 23/01/2012

Required Date: 27/01/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	51.1000	0.45	2.842105			
M304S11GA										**		3.6	
304/316 0.125 Sheet												B12-1-24	

Location	Loc Qty	Loc Code
MAT020	51.1	
119048	19.1	
120243	32	

D3907-1		Manufactured	No			130	Each	8.0000	2	12			
D3907-1										**			
Bushing													

Location	Loc Qty	Loc Code
WA005	8	
65920	4	
70673	1	
72317	1	
73008	2	

379121 → (16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

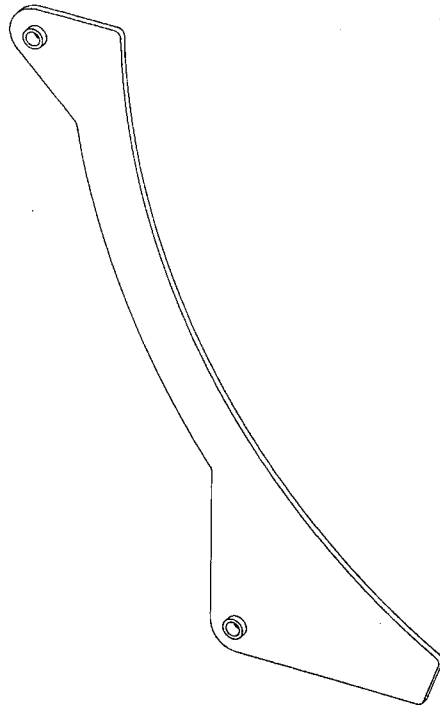
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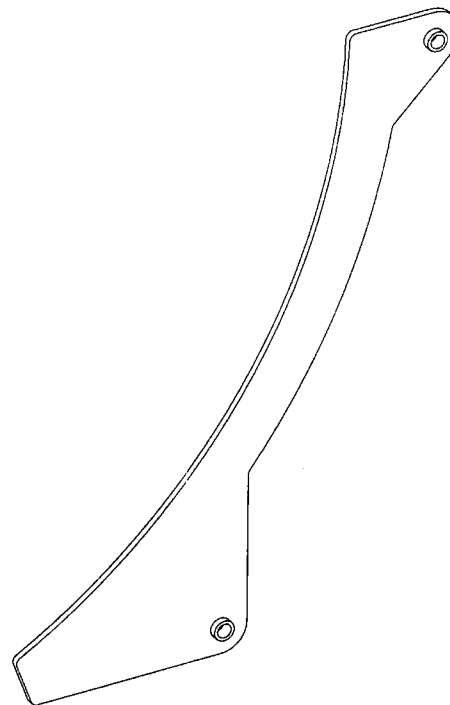
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

UNCORRECTED
SUBMIT
NO. 79154 M.C.S
12/01/23

RELEASED
07/04/23

- NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.73 lbs EACH
8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	09.04.03
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.04.03		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWING NO. D3929		SHEET 1 OF 3	
TITLE GUSSET ASSEMBLY		SCALE NTS	
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8 7 6 5 4 3 2 1

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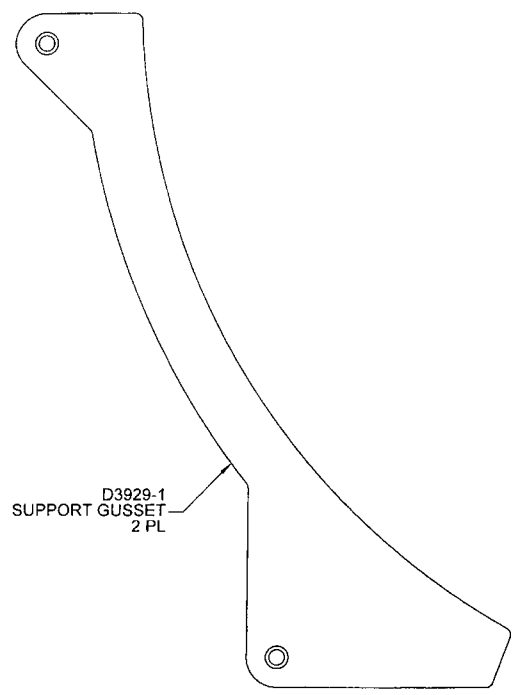
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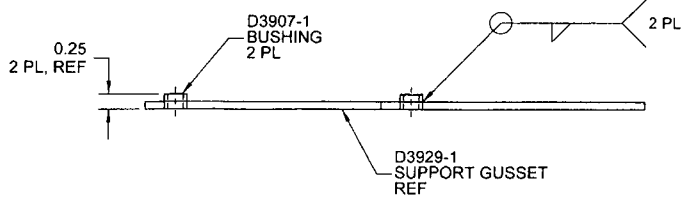
C

B

A

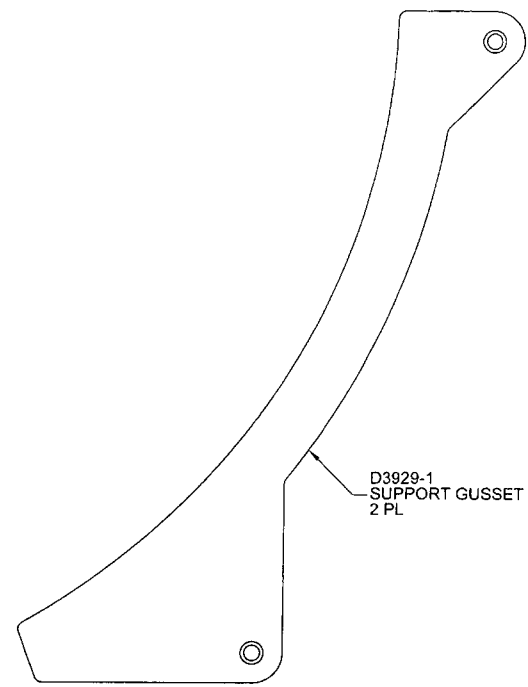


D3929-1
SUPPORT GUSSET
2 PL

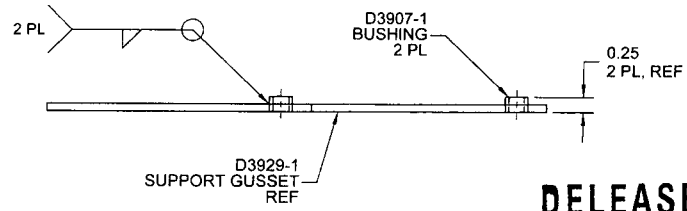


D3929-041 GUSSET ASSEMBLY

8 7 6 5 4 3 2 1



D3929-1
SUPPORT GUSSET
2 PL



D3929-042 GUSSET ASSEMBLY

RELEASED
09/04/22

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GUSSET ASSEMBLY	NTS
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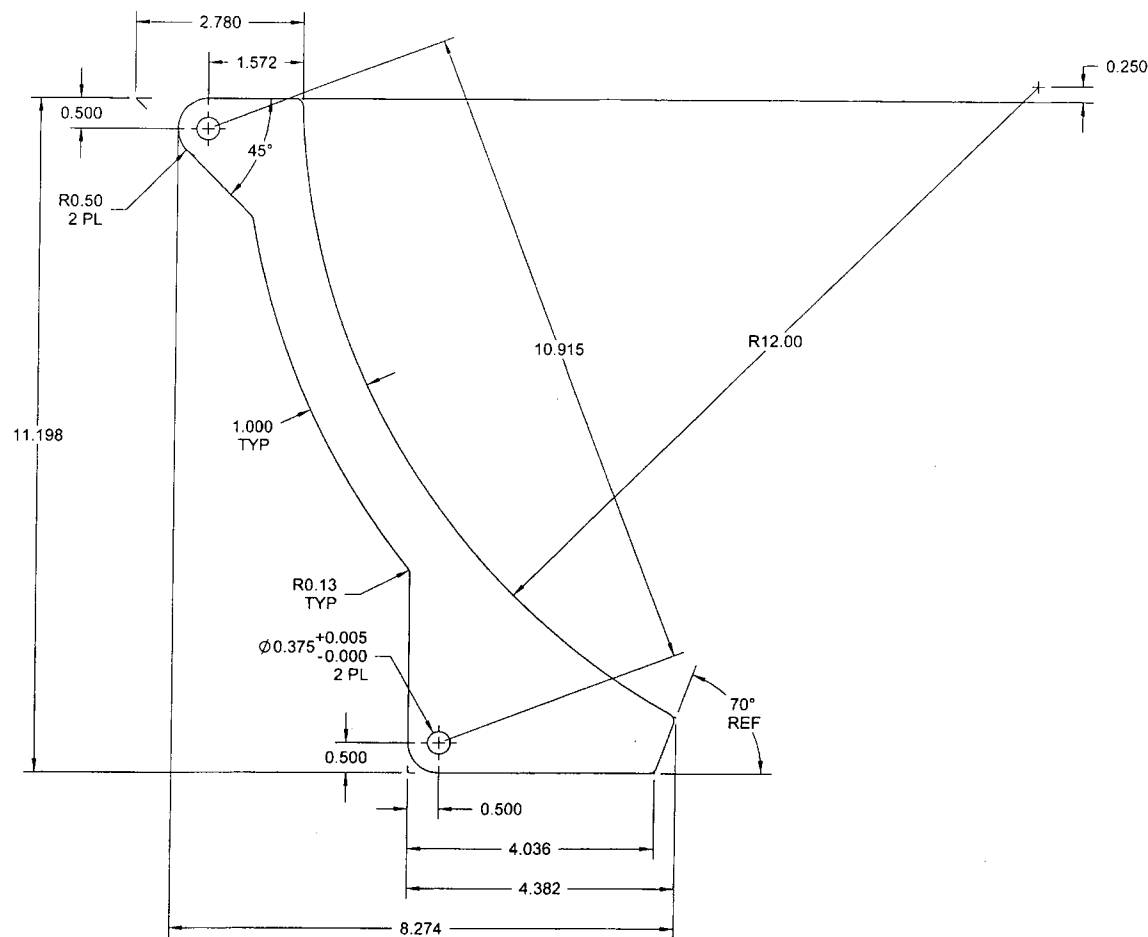
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D3929-1 SUPPORT GUSSET

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

RELEASED
9/04/22 JND

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GUSSET ASSEMBLY	NTS
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